

Work Order ID 64748

Wednesday, December 15, 2010 1:26:57 PM

Page 1

Item ID: D3564-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 12/15/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: PL

Date: 12/15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** ☐ Dwg Rev: D ☐ Prog

Rev: D ☐ 2-Deburr if necessary

HB 10-12-15

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 10-12-15

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 10/12/16

(24)

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Wednesday, December 15, 2010 1:26:57 PM

Page 2

Item ID: D3564-3

Accept

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Item Name: Wearshoe

Start Date: 12/15/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 10.00

Customer:




Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				(14)			
Brake NC	Memo Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 <input type="checkbox"/> Form Joggle as per Dwg D3564 on brake using Jig DT8157	0.00							
140  QC	QC5- Inspect part completeness to step on W/O	0.00				(14)			
Quality Control	Memo Ensure joggle as per dwg D3429	0.00							
150  Large Fab	Large Fab	0.00							
Large Fab	Memo Qty Description Batch <input type="checkbox"/> A/R 2059B Hardcoat 11/16/39 <input type="checkbox"/> Weld hardcoat as per Dwg D3437	0.00							

SP 10/12/17






8 10/12/17



EL 10-12-20 (X13)
pfo
Last page




Work Order ID 64748

Wednesday, December 15, 2010 1:26:57 PM

Page 3

Item ID: D3564-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearshoe					
Start Date: 12/15/2010	Start Qty: 10.00		Cust Item ID:		
Required Date: 12/17/2010	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		Sw 12/10		(413)			
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sw 12/10		(413)			
180  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 11/2588 Memo START TIME: 3:20 FINISH TIME: 1:55	0.00 0.00							13 BR 10-12-21

COVEN TEMPERATURE: 2.25

Work Order ID 64748

Wednesday, December 15, 2010 1:26:57 PM

Page 4

Item ID: D3564-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 12/15/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: F.P. 19 0.00

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/12/21 SF 13 SF

13 BR 10-12-21.

OK 10/12/22

P/10-12-22

(14)

Picklist Print

Page 1

Wednesday, December 15, 2010 1:27:02 PM

Work Order ID: 64748



Parent Item: D3564-3



Parent Item Name: Wearshoe



Start Date: 12/15/2010

Required Date: 12/17/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased				100	sf	113.0000	1.1	11.57895			
											1810-12-15		

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

113

111323

0

115953

113

115953

(14)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-12-20	150	took ① plate for testing alternate possible welding rod.	R	10-12-20	1	W 10/12/21	S 10/12/21	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	114748
Description: Wearshoe		Part Number:	D3564-3
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

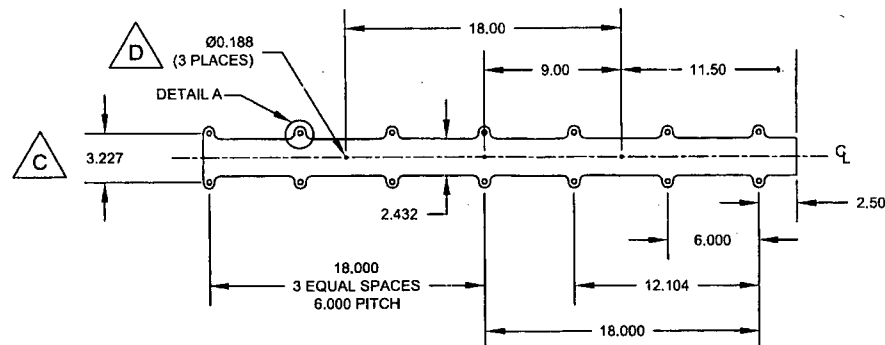
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

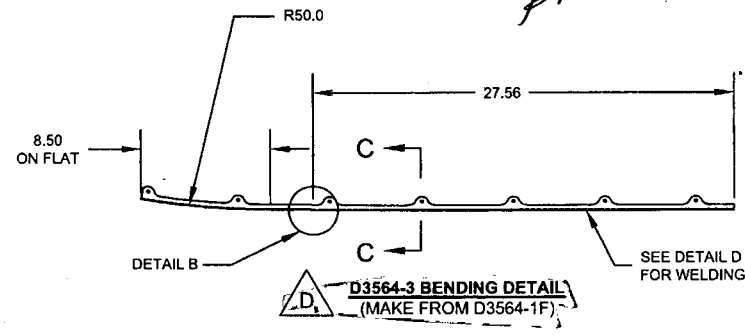
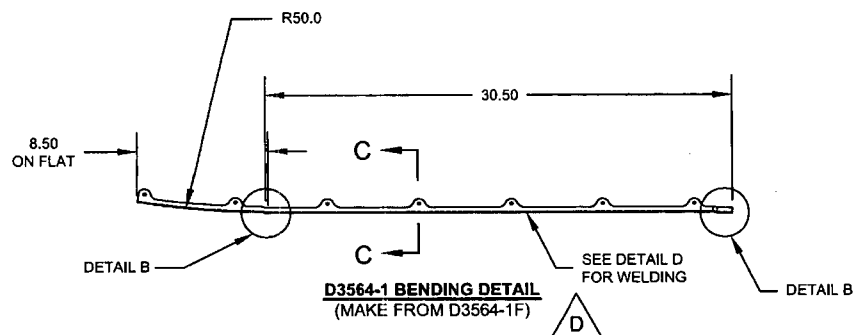
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.224	✓		✓ 1802	
2.432	+/-0.010	2.438	✓		✓	
2.50	+/-0.030	2.50	✓		✓	
6.000	+/-0.010	6.000	✓		✓ 1801	
12.10	+/-0.010	12.10	✓		✓	
18.000	+/-0.010	18.000	✓		✓	
18.000	+/-0.010	18.000	✓		✓	
18.00	+/-0.030	18.00	✓		✓	
9.00	+/-0.030	9.00	✓		✓	
11.50	+/-0.030	11.50	✓		✓	
0.300 x 0.300	+/-0.010	301 X 303	✓		✓	
Ø0.188	+0.005/-0.001	.187	✓		✓	
R0.375	+/-0.010	.375	✓		✓	
0.063	+/-0.010	.057	✓		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-12-15	Date: 10/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	



D3564-1F FLAT PATTERN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64748

RELEASED

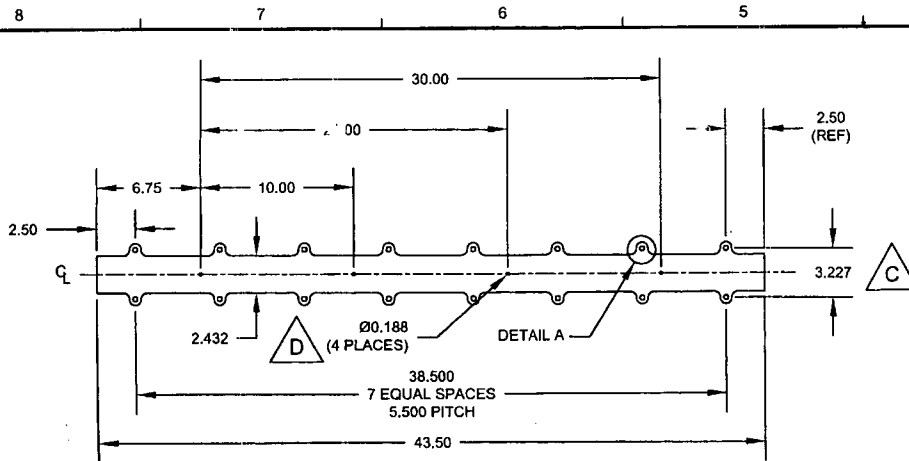
07.09.04

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

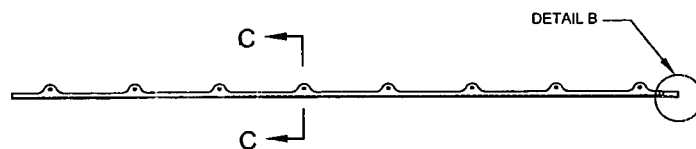
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

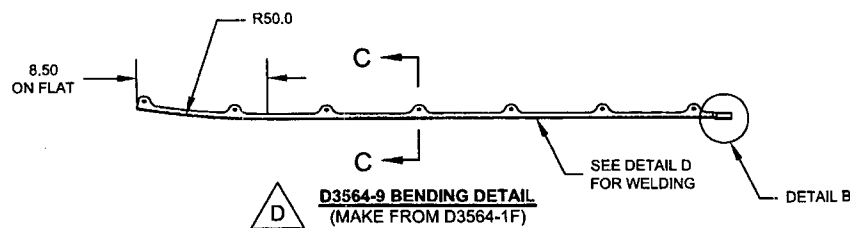
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



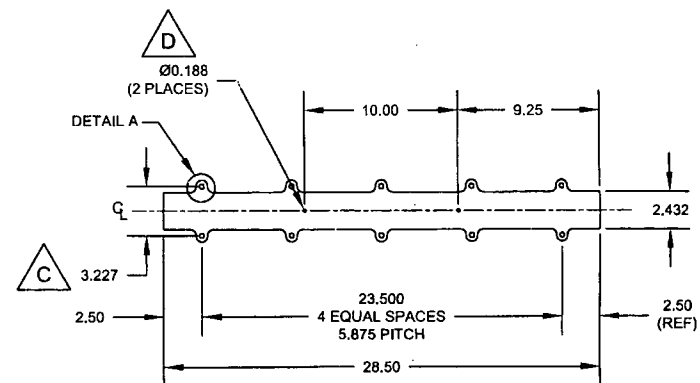
D3564-5F FLAT PATTERN



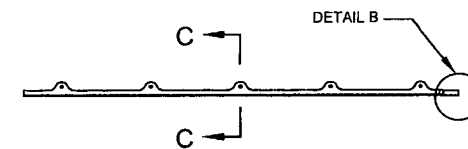
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



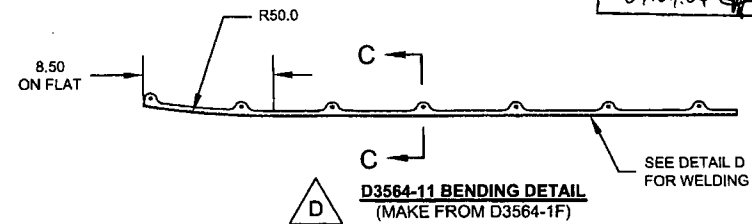
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



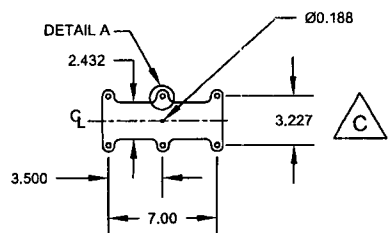
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

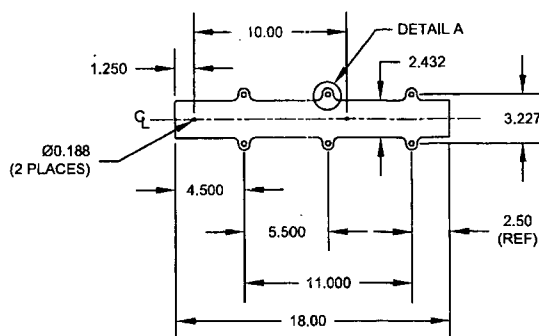
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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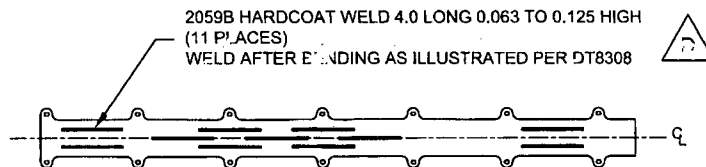
8 7 6 5 4 3 2 1



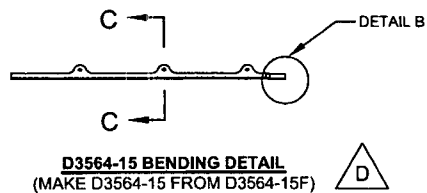
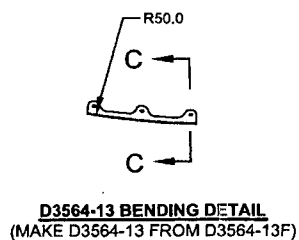
D3564-13F FLAT PATTERN



D3564-15F FLAT PATTERN



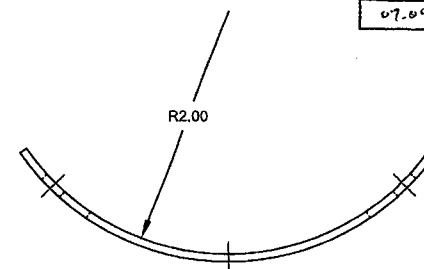
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



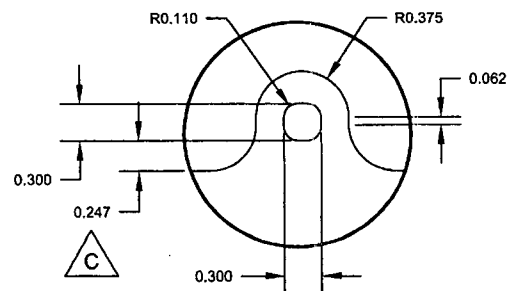
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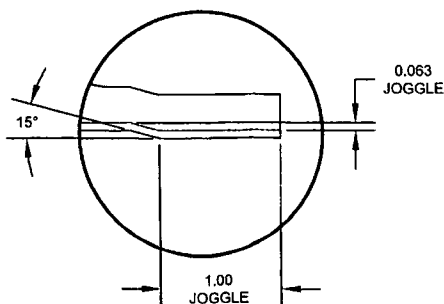
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
NEG. APPR.	PH	SHEET 3 OF 3	
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8 7 6 5 4 3 2 1